

Work Order ID 60035

June 23, 2010 8:38:12 AM

Page 1

Item ID: D3908-1

Accept

Revision ID:

Item Name: Lug Plate, Aft Crosstube

Setup Start

Stop

Start Date: 6/23/10 Start Qty: 8.00

Cust Item ID:

Required Date: 6/24/10 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3908

Prog Rev: E

Dwg Rev: E

Deburr as required

B10-6-23

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60035

June 23, 2010 8:38:12 AM



Page 2

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Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 6/23/10 Start Qty: 8.00



Cust Item ID:

Required Date: 6/24/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

5/10/06/23



Quality Control

150

Identify as per dwg & Stock Location 94

0.00



Packaging

Memo

0.00

10.6-23 100 SP

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/06/24

Quality Control

CY 10/6/24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June 23, 2010 8:38:10 AM

Page 1

Work Order ID: 60035

Parent Item: D3908-1

Parent Item Name: Lug Plate, Aft Crosstube



Start Date: 6/23/10

Required Date: 6/24/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA



304/316 0.125 Sheet

Purchased

No

100

sf

135.5059

0.0533

0.448842

.54

HB10-6-23



Location

Loc Qty

Loc Code

MAT

135.5059

114488

(10)

114488

7.5059

114799

128

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	40035
Description: Lug Plate, Aft Crosstube		Part Number:	D3908-1
Inspection Dwg: D3908	Rev: C	Page 1 of 1	

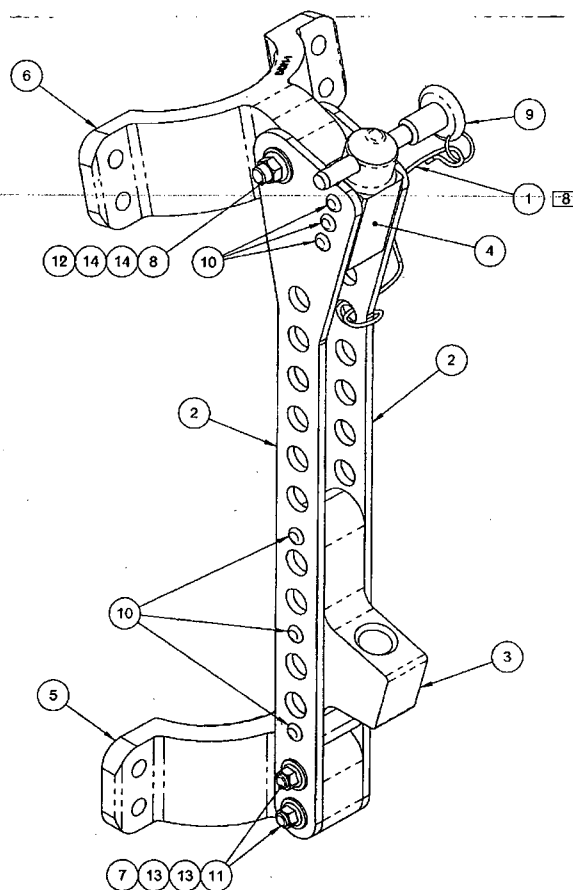
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	✓			
Ø0.191	+0.005/-0.001	.193	✓			
Ø0.257	+0.006/-0.001	.257	✓			
Ø0.375	+0.006/-0.001	.375	✓			
0.310	+/-0.010	.312	✗			
0.380	+/-0.010	.380	✗			
0.750	+/-0.010	.744	✗			
0.469	+/-0.010	.471	✗			
3.25	+/-0.030	3.248	✗			
0.65	+/-0.030	.652	✗			
0.63	+/-0.030	.625	✓			
1.587	+/-0.010	1.585	✓			
1.588	+/-0.010	1.585	✓			
5.46	+/-0.030	5.465	✗			
3.80	+/-0.030	3.803	✗			
2.13	+/-0.030	2.125	✗			
1.313	+/-0.010	1.310	✓			
0.375	+/-0.010	.374	✗			
0.625	+/-0.010	.622	✗			
11.15	+/-0.030	11.15	✓			
0.375	+/-0.010	.374	✗			
0.750	+/-0.010	.752	✗			
0.125	+/-0.010	.118	✗			

Measured by:	B	Audited by:	S	Preliminary Approval:	
Date:	10-6-23	Date:	10/06/23	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	
C	10.06.07	Dimensions updated per Dwg Rev C	KJ	

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT/STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

RELEASED
2010-05-28
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3908	REV. C
TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

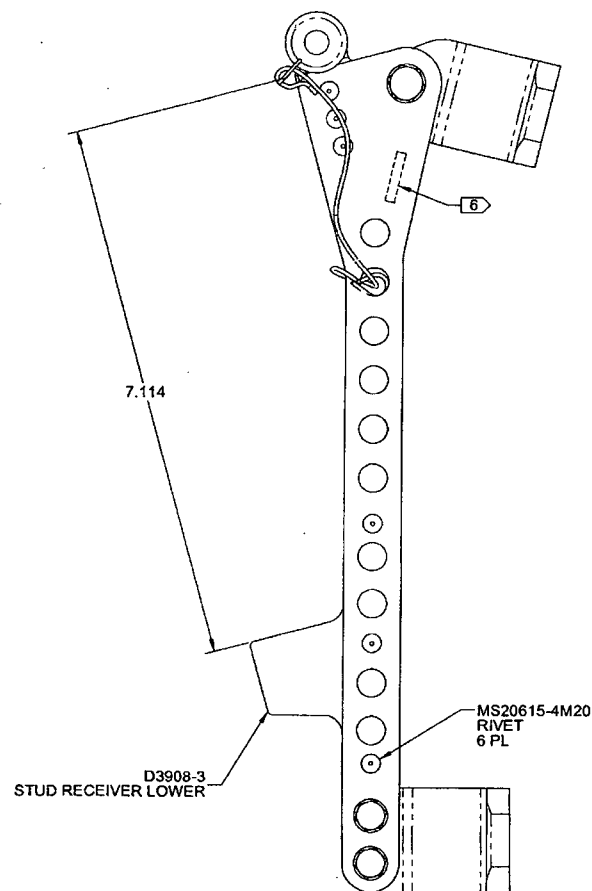
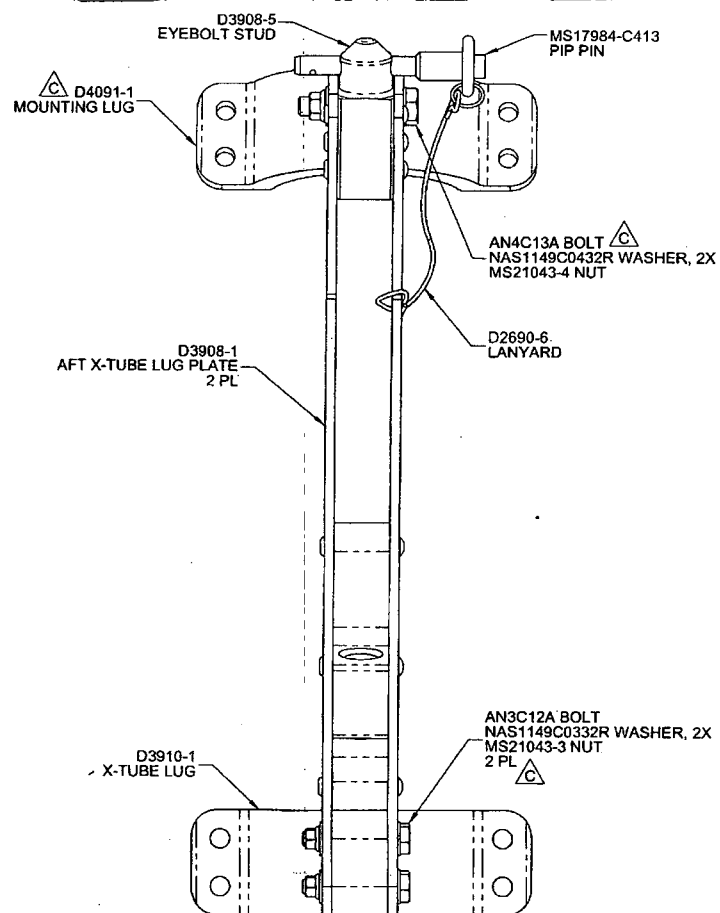
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
2010-05-28
JMP

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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8 7 6 5 4 3 2 1

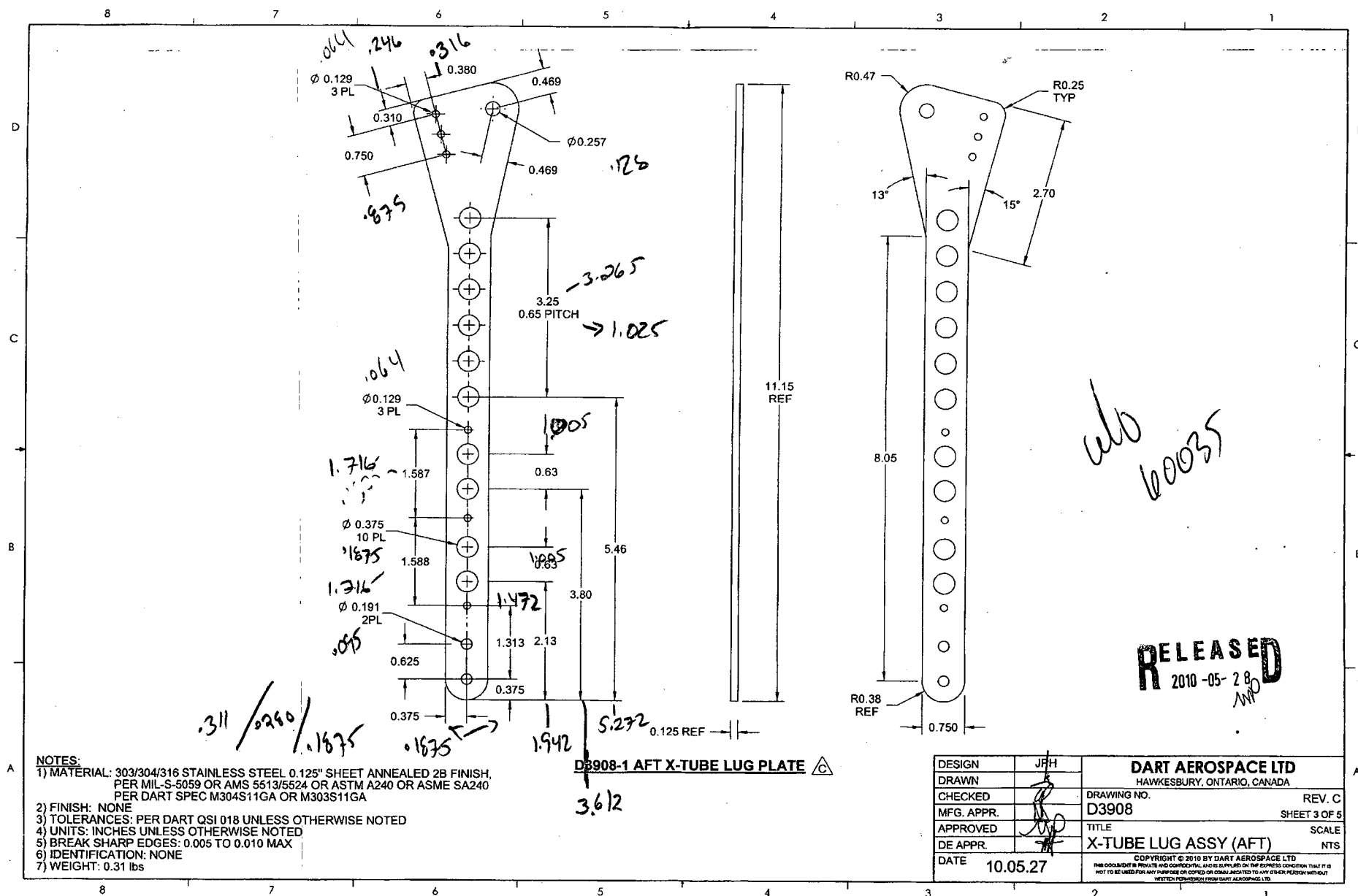
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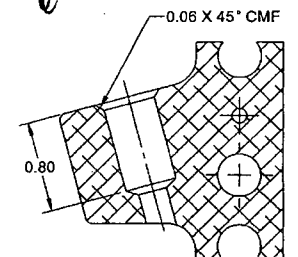
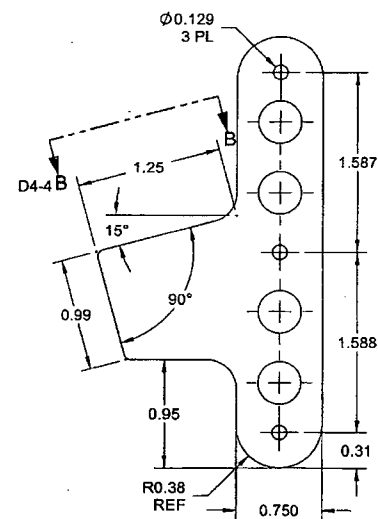
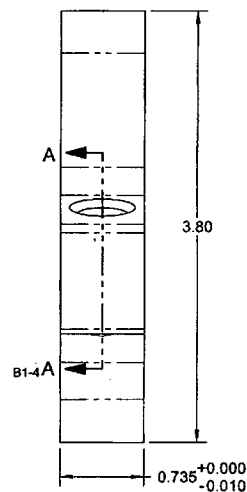
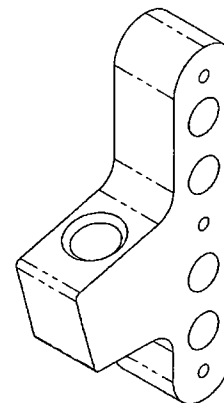
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SECTION A-A B6-4

RELEASE
2010-05-28

1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B

2) FINISH: NONE






3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

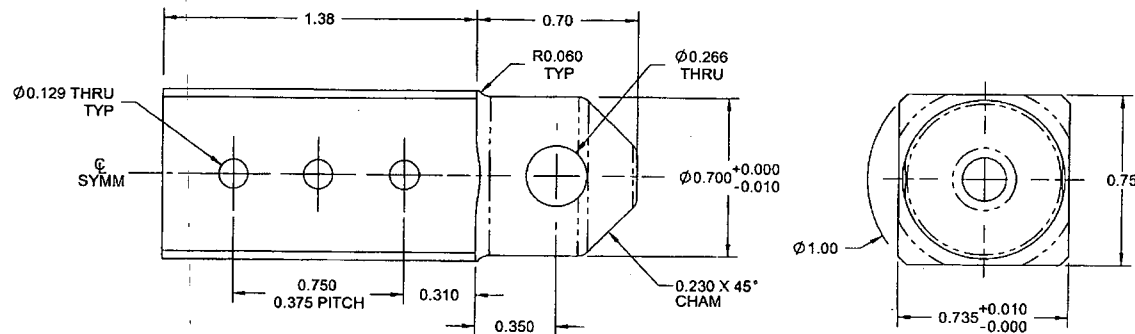
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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D3908-5 EYEBOLT STUD

RELEASED
2010-05-28
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 5 OF 5
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